

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 78385***78385***

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Item ID: D135-692-011

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bearpaw

Start Date: 09/01/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 23/01/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Packaging	0.00							
170									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D135-692-011								
	Location: <u>C11A</u>								
	PPP Rev: _____								
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

12/28 5/4

MLJ 12/02/28

ME
12-02-28

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Picklist Print

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Work Order ID: 78385

78385

Parent Item: D135-692-011

D135-692-011

Parent Item Name: Bearpaw

Start Date: 09/01/2012

Required Date: 23/01/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:C04.02.17Blank size changed, Tolerance added Step 3KJ/JLM
IPP Rev:D 08-04-16 Added Step 2 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN4-15A		Purchased	No			160	Each	21.0000	8	32			
---------	--	-----------	----	--	--	-----	------	---------	---	----	--	--	--

S4
AN4-15A
Bolt

** m/20187 SP.

Location	Loc Qty	Loc Code
ST358	21	
118648	4	
118706	17	

AN960JD416	NAS1149D0463J	Purchased	No			160	Each	0.0000	8	32			
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S4
AN960JD416
Washer

** m/119075 SP.

D2182B		Manufactured	No			160	f	530.8342	2	8			
--------	--	--------------	----	--	--	-----	---	----------	---	---	--	--	--

D2182B
Rubber Cushion

** SP.

Location	Loc Qty	Loc Code
ST410	530.83417	
66063	53.94817	
73932	476.886	

S4
→ m/20187 SP.

(D2182B060) Cut 4 at 6.00"

D2274		Manufactured	No			160	Each	149.0000	8	32			
-------	--	--------------	----	--	--	-----	------	----------	---	----	--	--	--

S4
D2274
Radius Block

** B 78589 SP. 32.

Location	Loc Qty	Loc Code
ST007	149	
73389	1	
76104	66	
77034	82	

SP 12-02-28.

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Work Order ID: 78385

78385

Parent Item: D135-692-011

D135-692-011

Parent Item Name: Bearpaw

Start Date: 09/01/2012

Required Date: 23/01/2012

Start Qty: 4.00

Required Qty: 4.00

D2519 Manufactured No 160 Each 52.0000 4 16

D2519

Clamp

**

SP.

Location

Loc Qty

Loc Code

ST459

52

65118

1

73499

51

160

Each

166.0000

8

**

IX.
15x

32

B79221 SP.

D2529

D2529

Washer

Location

Loc Qty

Loc Code

ST010

166

76086

166

160

Each

0.0000

2

**

8
B78386 ex SP.

D3049-1

D3049-1

Bearpaw

MS21042L4

Purchased No

160

Each

8,007.000

8

**

32

SP

MS21042L4

Nut

Location

Loc Qty

Loc Code

ST300

8007

117441

51

117601

342

118451

133

119017

2481

119075

5000

32x

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78385

Parent Item: D135-692-011

D135-692-011

Parent Item Name: Bearpaw

Start Date: 09/01/2012

Required Date: 23/01/2012

Start Qty: 4.00

Required Qty: 4.00

QS100-M24S

Purchased

No

160

Each

23.0000

4

16

**

SP 12-08-28.

S *QS100-M24S*
M Clamp

Location

Loc Qty

Loc Code

ST452

23

117291

3

118090

10

119537

10

3x
10x
3x

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REFERENCE ONLY

5. Additional AN960JD416 washers may be installed under the nuts to ensure 1.5-4 threads in safety on the bolts. Although not generally necessary, it is also acceptable to replace the AN4-15A bolts with longer or shorter AN4 bolts, if required.
6. Lower the aircraft

4. WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D135-692-011 Bearpaw Installation on model EC135 aircraft	11.8 lb 5.36 kg	0.0 in 0.0 m	0.0 lb-kp 0.0 m-kp	199.7 in 5.07 m	2356 in-lb 27.2 m-kp

5. PARTS LIST

Qty	Part Number	Description
X	D135-692-011	BEARPAW INSTALLATION
4	D2182B060	RUBBER CUSHION
8	D2274	RADIUS BLOCK
2	D3049-1	BEARPAW
8	D2529	WASHER
4	D2519	CLAMP
8	AN4-15A	BOLT
8	AN960JD416	WASHERS
8	MS21042L4	NUT (OR MS21042-4)
4	QS100M24S	CLAMP